

Work Order ID 136795

September 09, 2015 11:58:51 AM

136795

Page 1

Order to ship Sept 25

Item ID: D5155-047

Accept

N9000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Co-Pilot Collective Head Assembly (205)

Start Date: 9/9/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/23/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: SK Date: 20150909

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D5155	B
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110

Weld per dwg A/R Aluminum rod Batch: M129399 0.00

110

Large Fab

Memo

0.00

Large Fab

WELD D5054-1 to D5155-7 AS PER DWG

2 @ 15-9-24

120

QC9- Inspect visual per QSI004- Fusion Welds 0.00

120

QC

Memo

0.00

Quality Control

② 1509.24

DAS

9

9-89

130

QC5- Inspect part completeness to step on W/O 0.00

130

QC

Memo

0.00

Quality Control

② 15:09.24

DAS

9

9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Work Order ID 136795

136795

Page 2

Item ID: D5155-047 Accept *N19000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Co-Pilot Collective Head Assembly (205)
 Start Date: 9/9/2015 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 9/23/2015 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Outsource process-Anodize per QSI017 4.1.10.1	0.00							
140									
Outsource4	Memo	1.20							
Outsource process - Anodize	Issue P/O to ATG: 29893 Black Anodize as per Dwg D5155 C OF C REQUIRED								
150	Receive & Inspect for Damage & Mat'l Certs	0.00							
150									
Packaging	Memo	0.00							
Packaging	C OF C REQUIRED								
160	QC6- Inspect dimensions to drawing	0.00							
160									
QC	Memo	0.00							
Quality Control									

CZ SEP 25 2015

15/9/29 254

② 150929 DAS 9 9-00

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Work Order ID 136795

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136795

Page 3

Item ID: D5155-047 Accept ***N19000040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Co-Pilot Collective Head Assembly (205)
Start Date: 9/9/2015 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 9/23/2015 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170		0.00							
170						2	FF	SEP 30 2015	
Small Fab	Memo	0.00							
Small Fab	RE-PASS HELICOIL TAP IN THREADS AND INSTALL HELI-COIL ASSEMBLE AS PER DWG,								PTO
180	QC5- Inspect part completeness to step on W/O	0.00							
180						(2)			DAS 38 9-89
QC	Memo	0.00							SEP 30 2015
Quality Control									
190	Identify as per dwg & Stock Location: _____	0.00							
190									DAS 27 9-89
Packaging	Memo	0.00				2		SEP 30 2015	
Packaging									

PPP136794 Y1
57374 X1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setuṕ ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>136795</u> Part No. <u>D 5155-047</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																			
Date : <u>15-09-30</u>		Step #: <u>170</u>		QTY Effective : <u>91</u>			MRB (QSI042) Approval																																																																
Description Work Order Deviation				Disposition				DAS <u>9</u> 9-89 <u>150930</u>																																																															
MS16562-223 was install too deep and crooked. RC. no tooling.				Scrap 4 MS16562-223 and replace <u>M: 120229</u> tooling was made to install pin				Completed By <u>FF</u> <u>150930</u>																																																															
								Lead hand / Supervisor Approval Verification DAS <u>30</u> 9-89 <u>SEP 30 2015</u>																																																															
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Root Cause <table style="width:100%;"> <tr> <td>Environment ☐</td> <td>No Re-verification ☐</td> </tr> <tr> <td>Design ☐</td> <td>Operator ☐</td> </tr> <tr> <td>Doc/Data ☐</td> <td>Offset/Setup ☐</td> </tr> <tr> <td>Equip/Tooling ☒</td> <td>Supplier ☐</td> </tr> <tr> <td>Handling/Pre ☐</td> <td>Training ☐</td> </tr> <tr> <td>Material ☐</td> <td>Use for Testing ☐</td> </tr> <tr> <td>Internal Transport ☐</td> <td>Poor Information ☐</td> </tr> <tr> <td>Tribal Knowledge ☐</td> <td>Rushing ☐</td> </tr> <tr> <td>LOA ☐</td> <td>Product Improvement ☐</td> </tr> <tr> <td>Substation ☐</td> <td>Process Improvement ☐</td> </tr> <tr> <td>Past Expiry Date ☐</td> <td>Manufacturing Process ☐</td> </tr> <tr> <td>Misidentified ☐</td> <td>Past Due ☐</td> </tr> </table>				Environment ☐	No Re-verification ☐	Design ☐	Operator ☐	Doc/Data ☐	Offset/Setup ☐	Equip/Tooling ☒	Supplier ☐	Handling/Pre ☐	Training ☐	Material ☐	Use for Testing ☐	Internal Transport ☐	Poor Information ☐	Tribal Knowledge ☐	Rushing ☐	LOA ☐	Product Improvement ☐	Substation ☐	Process Improvement ☐	Past Expiry Date ☐	Manufacturing Process ☐	Misidentified ☐	Past Due ☐	FAULT CATEGORY <table style="width:100%;"> <tr> <td>Pressure/Forced ☐</td> <td>Temperature/Cure ☐</td> <td>Power Loss/Surge ☐</td> <td>☒ Positioned Wrong</td> </tr> <tr> <td>Bending ☐</td> <td>Set-up ☐</td> <td>Folio/Program ☐</td> <td>Outside Dimensions ☐</td> </tr> <tr> <td>Centre Not Concentric ☐</td> <td>BOM/Route ☐</td> <td>Grain ☐</td> <td>Over/Under tolerance ☐</td> </tr> <tr> <td>Cracks ☐</td> <td>Broken/Damage/Defect ☐</td> <td>Weld ☐</td> <td>Part Incorrect ☐</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave ☐</td> <td>Inspection Incomplete/Unqualified ☐</td> <td>Wrong Stock Pulled ☐</td> <td>Part Lost/Missing ☐</td> </tr> <tr> <td>Cuffs ☐</td> <td>Contamination ☐</td> <td>Out of Sequence ☐</td> <td>Part Moved ☐</td> </tr> <tr> <td>Crushing ☐</td> <td>Countersink ☐</td> <td>Off-set ☐</td> <td>Drawing ☐</td> </tr> <tr> <td>Heat Treat ☐</td> <td>Cut Too Short ☐</td> <td>Mislabeled ☐</td> <td>Finish ☐</td> </tr> <tr> <td>Wave/Twist in Tube ☐</td> <td>Instructions Incomplete/Unclear ☐</td> <td>Fit/Function ☐</td> <td>Misread ☐</td> </tr> <tr> <td>Marks/Chatter ☐</td> <td>Drill Holes ☐</td> <td>Misaligned/off center ☐</td> <td>Turning Sequence ☐</td> </tr> </table>				Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	☒ Positioned Wrong	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Environment ☐	No Re-verification ☐																																																																						
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OTHER : _____																																																																							

Work Order ID 136795***136795***

Page 4

Item ID: D5155-047

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Co-Pilot Collective Head Assembly (205)

Stop ***NS2***Start Date: 9/9/2015 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 9/23/2015 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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200	QC21- Final Inspection - Work Order Release	0.00							
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200

QC Memo

0.00

Quality Control

MLJ SEP 30 2015S 142 0150930

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
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Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ~ ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

Picklist Print

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Page 1

Work Order ID: 136795

136795

Parent Item: D5155-047

D5155-047

Parent Item Name: Co-Pilot Collective Head Assembly (205)

Start Date: 9/9/2015

Required Date: 9/23/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 15.05.07 NEW ISSUE DD VERF:JLM IPP
REV:B 15.07.02 AS PER DWG REV.B DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D5054-1 *D5054-1* Conduit		Manufactured	No				Each	9.0000		1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA002				9					
				116454				5					
				<u>117707</u>				4					
D5073-1 *D5073-1* Snap Ring		Manufactured	No				Each	63.0000					
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST145				63					
				117804				50					
				<u>117922</u>				13					
D5155-7 *D5155-7* Co-Pilot Collective Head (205)		Manufactured	No				Each	0.0000					
D5155-9 *D5155-9* Co-Pilot Collective Head (205)		Manufactured	No				Each	0.0000					
D5156-9 *D5156-9* Back Plate		Manufactured	No				Each	4.0000					

Location

st151

135053

Loc Qty

4

4

Loc Code

/

SEP 29 2015

**

EL 15-9-24

**

274

DAS
6
9-89

**

EL 15-9-24

**

+2
136799

DAS
6
9-89

**

22

DAS
6
9-89

Picklist Print

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Work Order ID: 136795

136795

Parent Item: D5155-047

D5155-047

Parent Item Name: Co-Pilot Collective Head Assembly (205)

Start Date: 9/9/2015

Required Date: 9/23/2015

Start Qty: 1.00

Required Qty: 1.00

90296A108

Purchased

No

Each

474.0000

11

90296A108

Heli-Coil Insert

**

FF

SEP 30 2015

Location

Loc Qty

Loc Code

GA

123496

300

2

m132757

300

20

ST564

174

m128972

174

MS16562-223

Purchased

No

Each

41.0000

2

MS16562-223

Spring Pin

**

Location

Loc Qty

Loc Code

ST316

41

120229

41

2

MS24693-24B

Purchased

No

Each

90.0000

7

MS24693-24B

Screw

**

FF

SEP 30 2015

Location

Loc Qty

Loc Code

GA

90

m132256

90

14

MS27641-3

Purchased

No

Each

4.0000

1

MS27641-3

BEARING

**

Location

Loc Qty

Loc Code

ST280

4

M128936

4

DAS

6

9-89

SEP 29 2015

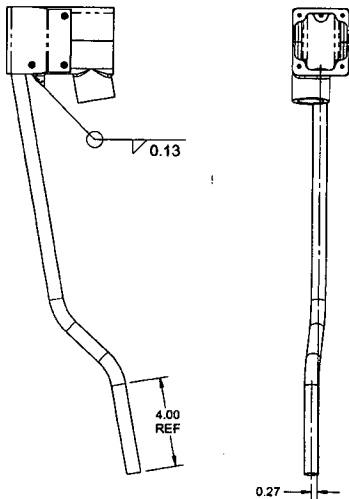
SL
S cap
MS/6 562-223

2015-09-30
130229

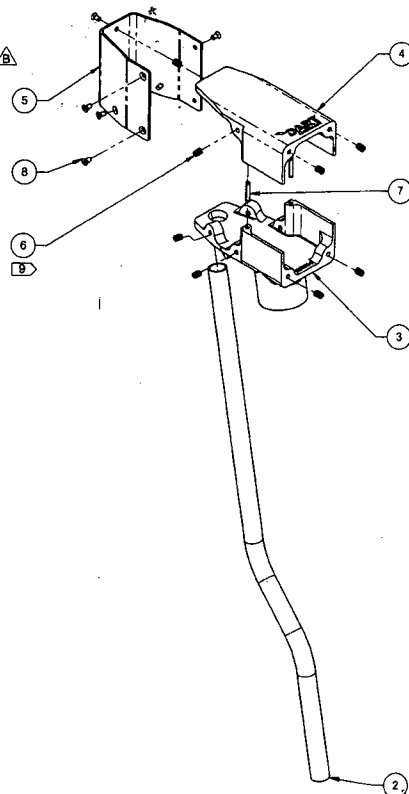
73

136795
STA
20150909

ITEM	QTY	P/N	DESCRIPTION
1	X	D5155-041	CO-PILOT COLLECTIVE HEAD ASSEMBLY (205)
2	1	D4410-7	CONDUIT
3	1	D5155-1	CO-PILOT COLLECTIVE HEAD (205)
4	1	D5155-9	CO-PILOT COLLECTIVE HEAD (205)
5	1	D5156-9	BACK PLATE
6	11	90296A108	HELI-COIL INSERT (6-32 X 0.276)
7	2	MS18562-223	SLOTTED SPRING PIN
8	7	MS24893-24B	SCREW, CSK 100"



D5155-041 WELDING DETAIL



D5155-041 CO-PILOT COLLECTIVE HEAD ASSEMBLY (205)

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IB CLASS 2 AFTER WELDING
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 1.08 lbs
 - 8) WELD PER DART QSI 004
 - 9) INSTALL AFTER ANODIZING

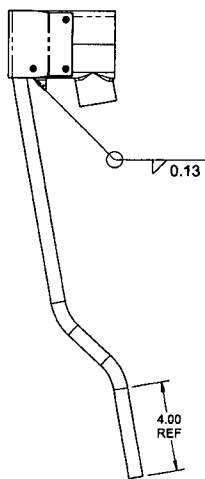
RELEASED

A.P. 2015 JUL 02 ECU 15-577

REVISE DIM: ZN D3-7, REVISE NOTE 2: ZN A5-13, A5-14, REVISE LENGTH OF PIN: ZN D6-1, D6-2, D6-3, D6-4, REVISE DEPTH: ZN C7-5, C7-7, C7-8, C7-11, C5-13, C4-14, REVISE DIM: ZN C7-5, C7-7, C7-8, C6-11, B7-13, B7-14, B2-5, B2-7, B2-9, B2-11, C2-13, C4-14, B4-6, D8-8, D6-10, D6-6, D5-8, D5-10, D5-12, B6-7, D7-12, C7-5, C7-7, C7-8, C6-11, D2-13, D2-14		VS	15.05.21
A NEW ISSUE		VS	14.09.10
REV.	DESCRIPTION	BY	DATE
DESIGN	VS	DART AEROSPACE LTD HAWKSBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	JFS	D5155	SHEET 1 OF 14
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
DATE	15.05.21	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL. NO PART OF THIS DOCUMENT MAY BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	

APPROVED

ITEM	QTY	P/N	DESCRIPTION
1	X	D5155-045	CO-PILOT COLLECTIVE HEAD ASSEMBLY (EAGLE SINGLE)
2	1	D4410-7	CONDUIT
3	1	D5155-5	CO-PILOT COLLECTIVE HEAD (EAGLE SINGLE)
4	1	D5155-9	CO-PILOT COLLECTIVE HEAD (205)
5	1	D5155-9	BACK PLATE
6	11	90296A108	HELL-COIL INSERT (6-32 X 0.276)
7	2	MS16562-223	SLOTTED SPRING PIN
8	7	MS24693-248	SCREW, CSK 100"

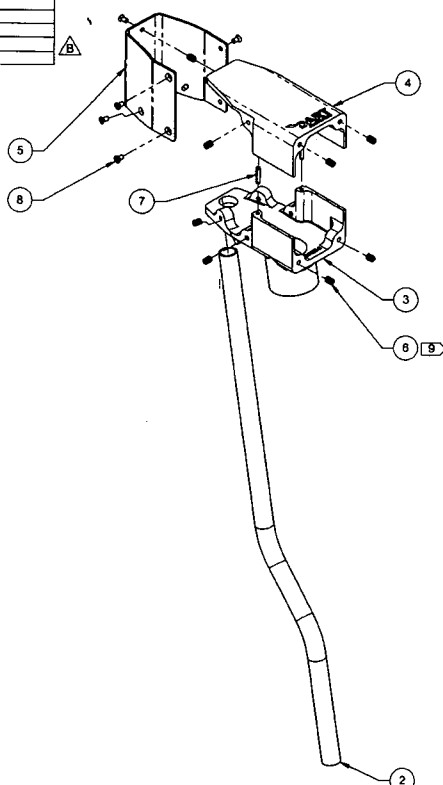


D5155-045 WELDING DETAIL

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 AFTER WELDING
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.06 lbs
- 8) WELD PER DART QSI 004
- 9) INSTALL AFTER ANODIZING

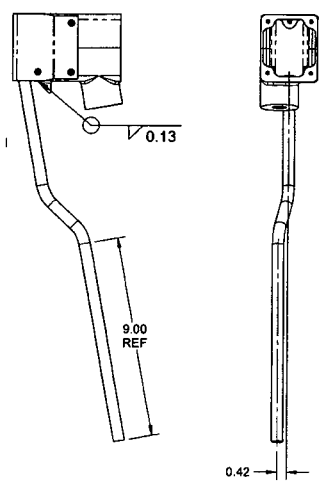
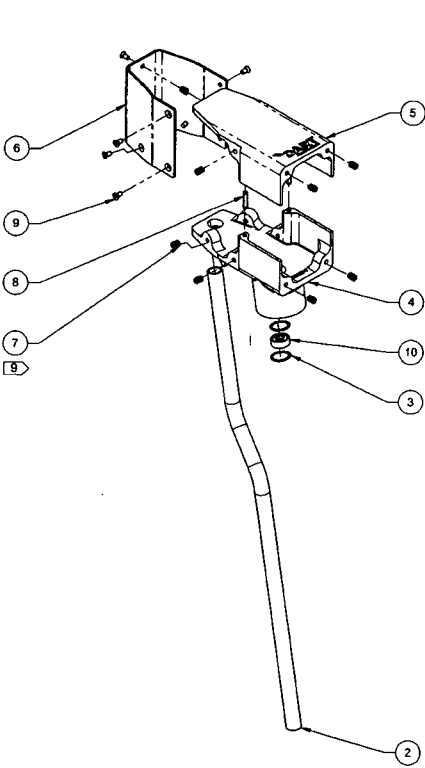
D5155-045 CO-PILOT COLLECTIVE HEAD ASSY (EAGLE SINGLE)



RELEASED
A-E 2015 JUL 02

DESIGN	VS	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO. D5155	REV. B
MFG. APPR.	JFS		SHEET 3 OF 14
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
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ITEM	QTY	P/N	DESCRIPTION
1	X	D5155-047	CO-PILOT COLLECTIVE HEAD ASSEMBLY
2	1	D5054-1	CONDUIT
3	2	D5073-1	SNAP RING
4	1	D5155-7	CO-PILOT COLLECTIVE HEAD (205)
5	1	D5155-9	CO-PILOT COLLECTIVE HEAD (205)
6	1	D5156-9	BACK PLATE
7	11	90296A108	HELI-COIL INSERT (6-32 X 0.276)
8	2	MS16562-223	SLOTTED SPRING PIN
9	7	MS24693-24B	SCREW, CSK 100°
10	1	MS27641-3	BEARING



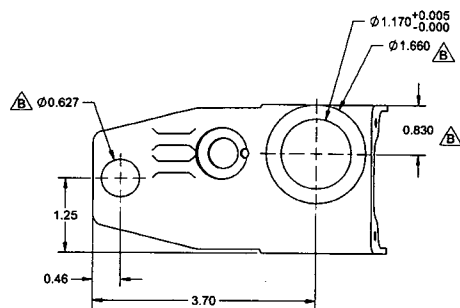
D5155-047 WELDING DETAIL

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 AFTER WELDING
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 1.14 lbs
 - 8) WELD PER DART QSI 004
 - 9) INSTALL AFTER ANODIZING

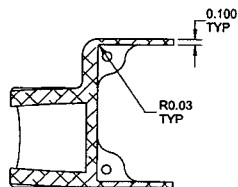
D5155-047 CO-PILOT COLLECTIVE HEAD ASSY
FOR 205 WITH 204-001-290-5 STICK AND THROTTLE ASSEMBLY INSTALLED

DESIGN	VS	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO	REV. B
MFG. APPR.	JFS	D5155	SHEET 4 OF 14
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
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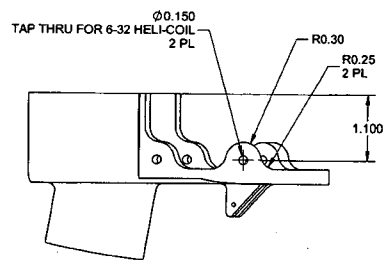
RELEASED
a.e. 2015 JUL 02



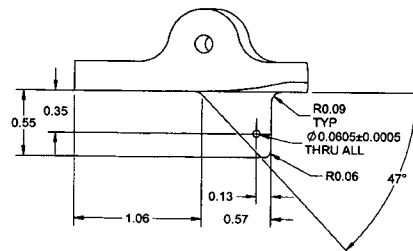
VIEW B-B
B5-5



SECTION D-D
D6-5



VIEW C-C
D7-5



DETAIL E
B7-5

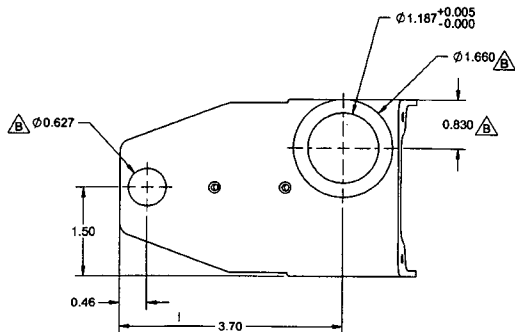
RELEASED
A.E. 2015 JUL 02

- NOTES:**
 1) MATERIAL: N/A
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: N/A

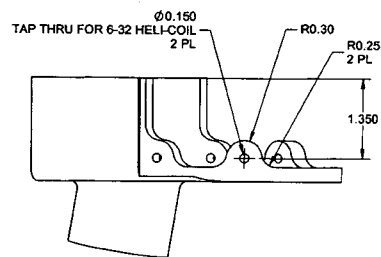
D5155-1 CO-PILOT COLLECTIVE HEAD (205)
DETAIL VIEWS

DESIGN	VS	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	JFS	D5155	SHEET 6 OF 14
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
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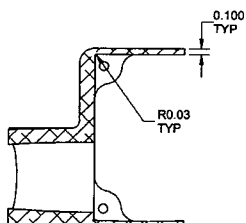
APPROVED	DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D5155 TITLE CO-PILOT COLLECTIVE HEAD COPYRIGHT © 2016 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRINTED AND COPIED FOR THE EXCLUSIVE USE OF THE USER. IT IS NOT TO BE REPRODUCED OR FOR PUBLICATION OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	REV. B SHEET 7 OF 14 SCALE NTS
	DRAWN	VS		
	CHECKED	RF		
	MFG. APPR.	JFS		
	APPROVED	HS		
	DE APPR.	DS		
DATE	15.05.21			



VIEW G-G
B6-7



VIEW H-H
D7-7



SECTION I-I
D6-7

RELEASED
A. 2015 JUL 02

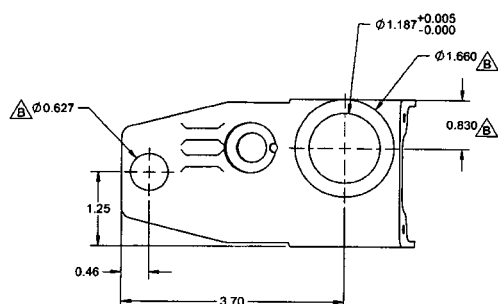
- NOTES:**
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: N/A

D5155-3 CO-PILOT COLLECTIVE HEAD (212)
DETAIL VIEWS

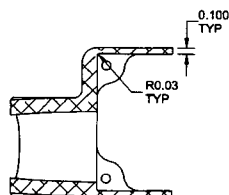
APPROVED

DESIGN	VS	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	JFS	D5155	SHEET 8 OF 14
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CO-PILOT COLLECTIVE HEAD NTS	
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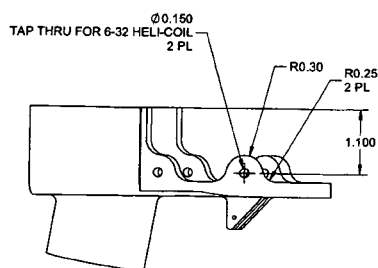
DESIGN	VS	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	JFS	D5155	SHEET 8 OF 14
APPROVED	VS	TITLE	SCALE
DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
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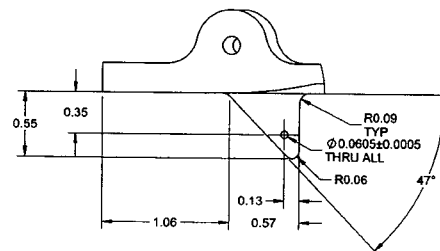
VIEW K-K
B6-9



SECTION M-M
D6-9



VIEW L-L
D7-9



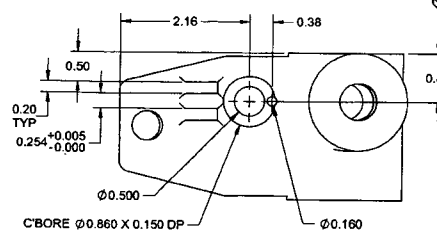
DETAIL N
B7-9

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A.P. 2015 JUL 02

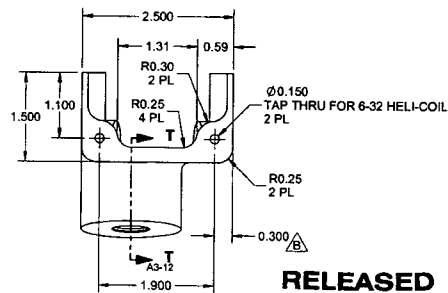
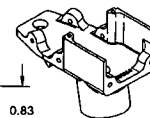
- NOTES:**
 1) MATERIAL: N/A
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: N/A

D5155-5 CO-PILOT COLLECTIVE HEAD (EAGLE SINGLE)
DETAIL VIEWS

DESIGN	VS	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	JFS	D5155	SHEET 10 OF 14
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
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VIEW O-O



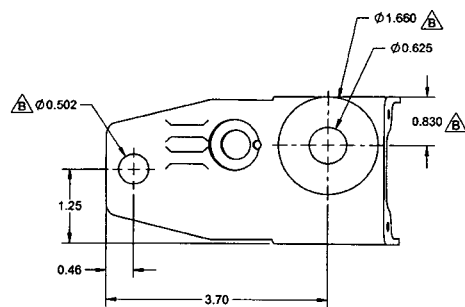
RELEASED

A.P. 2015 JUL 02

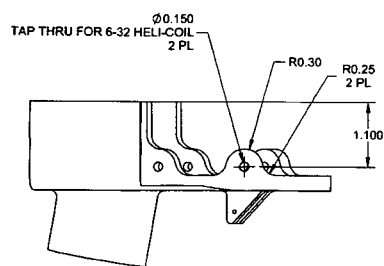
NOTES:

- D5155-7 CO-PILOT COLLECTIVE HEAD (205)**

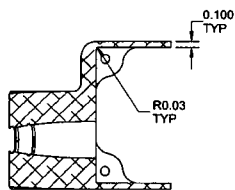
DESIGN	VS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RV	DRAWING NO.	REV. B
MFG. APPR.	JFS	D5155	SHEET 11 OF 14
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
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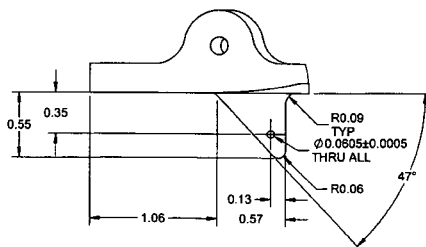
VIEW P-P
95-11



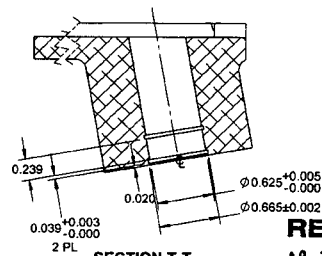
VIEW Q-Q
D7-11



SECTION R-R
C6-11



DETAIL S
B6-11



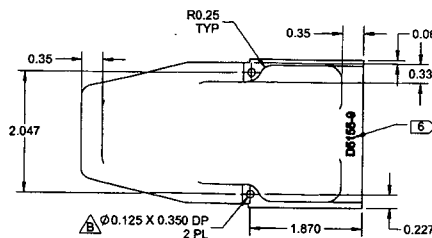
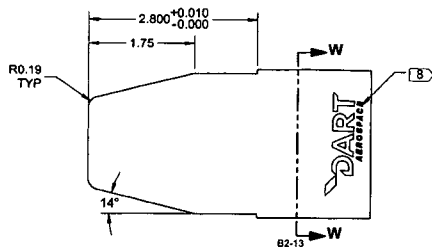
SECTION T-T
B2-11

RELEASED
A.R. 2015 JUL 02

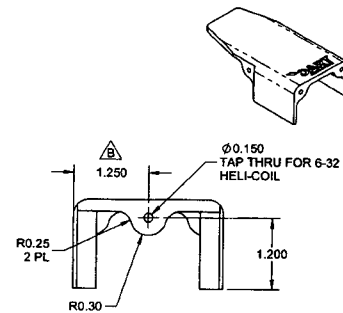
- NOTES:**
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: N/A

D5155-7 CO-PILOT COLLECTIVE HEAD (205)
DETAIL VIEWS

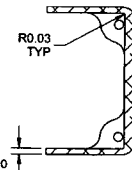
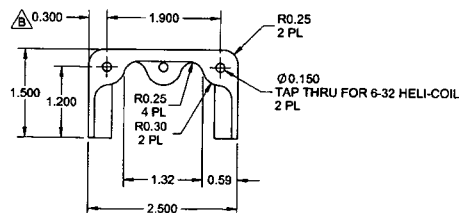
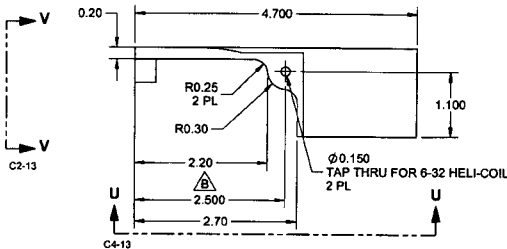
APPROVED	DESIGN	VS	DART AEROSPACE LTD	
	DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
	CHECKED	RF	DRAWING NO.	REV. B
	MFG. APPR.	JFS	D5155	SHEET 12 OF 14
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
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VIEW U-U
B7-13



VIEW V-V
B8-13



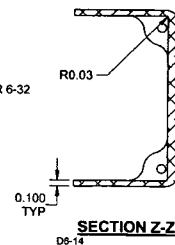
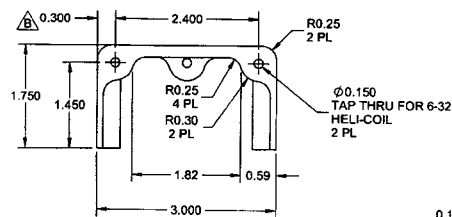
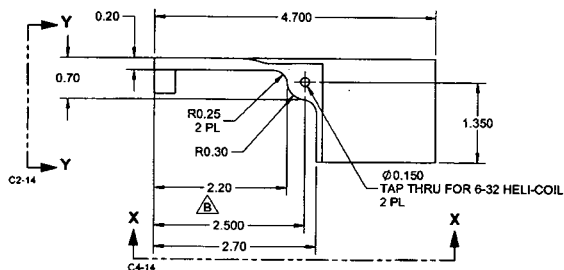
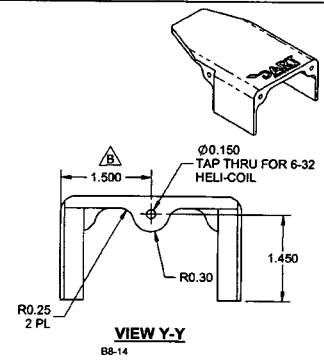
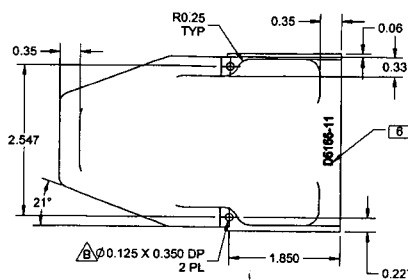
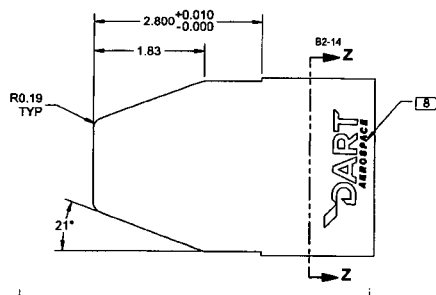
SECTION W-W
D6-13

RELEASED
4.8.2015 JUL 02

- NOTES:
- 1) MATERIAL: 6061-T6/T651/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
 - 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II
OR IIB CLASS 2
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3 IN THIS AREA TO MAX DEPTH
OF 0.010 WITH A MIN. TOOL RAD OF R0.010
 - 7) WEIGHT: 0.31 lbs
 - 8) ENGRAVE "DART" LOGO AS SHOWN 0.003-0.005 DP
 - 9) UNDIMENSIONED FEATURES DEFINED BY D5155-9 SLDPR

D5155-9 CO-PILOT COLLECTIVE HEAD (205)

APPROVED	DESIGN	VS	DART AEROSPACE LTD	
	DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
	CHECKED	RF	DRAWING NO.	REV. B
	MFG. APPR.	JFS	D5155	SHEET 13 OF 14
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
	DATE	15.05.21	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PREPARED AND CONTROLLED BY DART AEROSPACE LTD. THE COMPANY ACCEPTS FULL RESPONSIBILITY FOR THE CONTENT AND ACCURACY OF THE INFORMATION CONTAINED HEREIN. IT IS NOT TO BE RELEASED FOR ANY PURPOSE OR FOR ANY OTHER PERSON'S USE WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	



NOTES:

- 1) MATERIAL: 6061-T6/T651/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T68
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II
OR IB CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3 IN THIS AREA TO MAX DEPTH
OF 0.010 WITH A MIN. TOOL RAD OF R0.010
- 7) WEIGHT: 0.36 lbs
- 8) ENGRAVE "DART" LOGO AS SHOWN 0.003-0.005 DP
- 9) UNDIMENSIONED FEATURES DEFINED BY D5155-11.SLDPRT

D5155-11 CO-PILOT COLLECTIVE HEAD (212)

RELEASED
A.R. 2015 JUL 02

APPROVED	DESIGN	VS	DART AEROSPACE LTD	
	DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
	CHECKED	RF	DRAWING NO.	REV. B
	MFG. APPR.	JFS	D5155	SHEET 14 OF 14
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
	DATE	15.05.21	COPYRIGHT © 2013 BY DART AEROSPACE LTD	
	THIS DOCUMENT IS PREPARED BY DART AEROSPACE LTD. AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.			



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Roc'land, On K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 63934

Date: 29-Sep-15

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description		
2 ea	Part: D5155-9 CO-PILOT HEAD BLACK ANODIZE MIL-A-8625 TYPE II CLASS 2 Job: 20150732 PO: PO29893 Line:	Rev: B	/
2 ea	Part: D5155-047 CO-PILOT HEAD ASSY BLACK ANODIZE MIL-A-8625 TYPE II CLASS 2 Job: 20150733 PO: PO29893 Line:	Rev: B	/
Certificate of Conformance A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order. ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY DATE: <u>29/9/15</u> CERTIFIED SIGNATURE: <u></u> RECEIVER SIGNATURE: _____ 15/9/29 SL			



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO29893

Purchase Order Date 9/25/2015

PO Print Date 9/29/2015

Page Number 1 of 3

Order From :

VC-ATG001

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

RECEIVED

Contact Name

Vendor Phone 613-446-4544

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Ship To Contact

Ship To Phone

Ship Via: VENDOR'S TRUCK

Ship Acct:

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	136799	D5155-9 CO-PILOT HEAD REV. B	9/29/2015 Yes 9/29/2015 Black Anodize per MIL-A-8625F Type I or IB or IC or II or IIB Class 2, Type III Class 2		2.00	\$31.25	\$62.50
						Line Total:	\$62.50
2	136795	D5155-047 CO-PILOT HEAD ASSY REV. B	9/29/2015 Yes 9/29/2015 Black Anodize per MIL-A-8625F Type I or IB or IC or II or IIB Class 2, Type III Class 2		2.00 ✓ 15/9/29 SL	\$31.25	\$62.50
						Line Total:	\$62.50
3	135457	646.3313 UPPER GUIDE REV. N/C	9/29/2015 Yes 9/29/2015 FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N		10.00	\$22.50	\$225.00

Note:

9/29/2015

[REDACTED]					
1	d5155-9	BLACK ANODIZE	2	LOT 125.00	
2	D5155-047	BLACK ANODIZE	2		
3	646.3313	HARD BLACK & PRIME	10	LOT 360.00	
4	646.3610	HARD BLACK & PRIME	6		
REPEAT JOBS		[REDACTED]	NO		
PO# PO29893					

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE Form One			3. Form Tracking Number: SO126107-1	
4. Organizations Name and Address: Dart Aerospace Ltd., 1270 Aberdeen Street, Hawkesbury, Ontario, K6A 1K7, CANADA Tel: 1 (613) 632-5200 Fax: 1 (613) 632-5246 www.dartaero.com					5. Work Order/Contract/Invoice M14017	
6. Item:	7. Description:	8. Part Number:	9. Quantity:	10. Serial/Batch Number:	11. Status/Work:	
1	Left Hand Pilot In Command, Mechanical Only	D205-803-223	1	B136795	NEW	
12. Remarks: Customer returned D5155-041 / B134144 from Kit D205-803-213 originally sold in Kit D205-803-213 on Sales Order SO121028. Customer requested D5155-047 to convert kit to P/N D205-803-223.						
13a. Certifies that the items identified above were manufactured in conformity to: ☒ Approved design data and are in a condition for safe operation. ☐ Non-approved design data specified in Block 12.				14a. ☐ CAR 571.10 Maintenance Release ☐ Other regulations specified in Block 12 Certifies that unless otherwise specified in Block 12, the work identified in Block 11 and described in Block 12, has been performed in compliance with the <i>Canadian Aviation Regulations</i> .		
13b. Signature  DAG 29 0-89		13c. Approval Organization Number 9-89		14b. Signature		14c. Approved Organization Number
13d. Name Patrick Smith		13e. Date (dd/mmm/yyyy): 04/Aug/2016		14d. Name		14e. Date (dd/mmm/yyyy):
30 Dec 2008(Previously form 24-0078)						
Installer Responsibilities This certificate does not constitute authority to install. Installers working in accordance with the national regulations of a country other than the authority specified in Block 1, must ensure that their regulations recognize certifications from the country specified. Statements 13a or 14a do not constitute installation certification. In all cases, the aircraft technical record must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.						



DART Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 5200
Fax: 613 632 5246
accounting@dartaero.com

INVOICE * REPRINT *****

Invoice ID : INV123942
Sales Order ID : SO121028
Invoice Date : 7/15/2015
Ship Date : 7/15/2015 10:15:00 AM
Customer PO ID : CSR15-201 / M12626 / Case 8861

Page Number : Page 1 of 1

Prepared By :

Bill To :
CHI AVIATION
3679 BOWEN RD
HOWELL, MICHIGAN 48855
UNITED STATES

CCONS01

Ship To :
HELMAX AVIATION
3028 PEACEKEEPER WAY, SUITE B-227
MCCLELLAN, CALIFORNIA 95652
UNITED STATES

Order Date: 4/15/2015 3:49:17 PM
Freight Acct #: 1517-9324-0
AR Terms: Net 30
Due Date **Amount**
8/14/2015 \$0.00

FOB: Ex Works DART Aerospace
Currency Type : USD
Ship Method: FedEx Intl Priority
AWB: 561296070221

Line Nbr/	Item ID / Item Name	Unit of Measure	Shipped Qty	CD	Unit Price	Discount %	Sales Tax	Extended Price
1	D205-803-213 / Left Hand Pilot in Command - Medium/Standard Design, Mechanical 205	Each	5.0000	FN	\$0.0000	100.00%	0.00%	\$0.00
			Backorder Qty :	0.0000				

Lot Number

Lot Trans Qty

134093

Orig. Batch, order

DS155-041-⁵B134144

Line Item Total: \$0.00

2	D212-803-217 / Left Hand Pilot in Command - Medium/Standard Design, Mechanical 212/412	Each	1.0000	FN	\$0.0000	100.00%	0.00%	\$0.00
			Backorder Qty :	0.0000				

Lot Number

Lot Trans Qty

134092

1

Line Item Total: \$0.00

Subtotal: \$0.00
Sales Tax: \$0.00
Shipping Charges: \$0.00
Total: \$0.00
Payments Received: \$0.00
Balance Due: \$0.00

Remittance Address: Remittance address as stated above.
Note: A minimum 15% restocking fee is applicable on all standard items.
Custom items are non-refundable. Full warranty and return authorization details are available at www.dartaerospace.com
GHST/HST 10127 2607

email message and permanently delete and destroy the original message and any and all copies, including printouts and electronic copies on any computer system.

From: Support Hawkesbury [mailto:support.on@dartaero.com]
Sent: Thursday, April 28, 2016 6:21 AM
To: srandalls@helimaxaviation.net
Cc: tdagnillo@chiaviation.com
Subject: RE: PR 7013 & 7267

Hi Steve,

I hope you are well. Can you please confirm the batch number of the D5155-041 Collective head you would like to exchange/return? Also has this unit been installed or flown?

Thank you,
Jennifer

From: Steven Randalls [mailto:srandalls@helimaxaviation.net]
Sent: Tuesday, April 26, 2016 5:35 PM
To: Mike DiDomenico <mdidomenico@dartaero.com>; 'Tom Dagnillo' <tdagnillo@chiaviation.com>
Subject: RE: PR 7013 & 7267

Mike,

RA112302

I would like to see if we could do a no cost exchange of a D5155-041 Collective Head for a D5155-047 Collective Head.
When the order was placed for the Collective heads for the six helicopters we have, they were all requested at the same time.

I have one Bell 205 that has the earlier style collective stick and thus needs the D5155-047 head.

We are just about finished with the LH PIC Collective head upgrade on the fleet and will be returning all of the first generation collective heads to you under a previously issued DART RMA# RA112115.

Thanks Mike. Let me know if you have any questions.

Regards,

Steve Randalls
Director of Maintenance
Accountable Manager
866.931.4354
530.687.2460 cell
866.931.4355 fax

HELI MAX
AVIATION INC.

Confidentiality Statement: This email message, including any attachments, is intended solely for the use of the addressee(s) named above. This communication may contain privileged and/or confidential material. If you are not the intended recipient, you have received this communication in error, and any review, use, printing, copying, or other dissemination of

7. PARTS LIST - MEDIUM COLLECTIVE HEAD KITS

Qty -211	Qty -213	Qty -215	Qty -217	Qty -219	Qty -221	Qty -223	Part Number	Description
X							D205-803-211	LEFT HAND PILOT IN COMMAND, COMPLETE KIT
	X						D205-803-213	LEFT HAND PILOT IN COMMAND, MECHANICAL ONLY
		X					D212-803-215	LEFT HAND PILOT IN COMMAND, COMPLETE KIT
			X				D212-803-217	LEFT HAND PILOT IN COMMAND, MECHANICAL ONLY
				X			D212-803-219	LEFT HAND PILOT IN COMMAND, EAGLE SINGLE
					X		D205-803-221	LEFT HAND PILOT IN COMMAND, COMPLETE KIT
						X	D205-803-223	LEFT HAND PILOT IN COMMAND, MECHANICAL ONLY
1	1						D5155-041	CO-PILOT COLLECTIVE HEAD ASSEMBLY (205)
		1	1				D5155-043	CO-PILOT COLLECTIVE HEAD ASSEMBLY (212)
				1			D5155-045	CO-PILOT COLLECTIVE HEAD ASSEMBLY (EAGLE SINGLE)
					1	1	D5155-047	CO-PILOT COLLECTIVE HEAD ASSEMBLY (205 WITH THE 204-001-290-5 STICK AND THROTTLE ASSY INSTALLED)
1	1			1	1	1	D5156-1	FACE PLATE
1	1			1	1	1	D5156-3	FACE PLATE
		1	1				D5156-5	FACE PLATE
		1	1				D5156-7	FACE PLATE
1	1			1	1	1	D4410-9	TRIGGER
1	1			1	1	1	D5055-1	PLACARD
1	1	1	1	1	1	1	D5055-3	PLACARD
		1	1				D5055-5	PLACARD
		1	1				D5055-7	PLACARD
		1	1				D5055-9	PLACARD
1	1	1	1	1			D4411-7	PLACARD
		1					27ET51-T	SWITCH (ALT P/N 212-075-153-3)
1					1		2PB744-T2	SWITCH
		3					30-037-26	DIODE ASSEMBLY
		2					30-037-3	DIODE ASSEMBLY
1	1			1	1	1	AN565F8H9	SETSCREW
		3					AN861-6T	WASHER
		1					51MKY-5-J	SWITCH
1					1		C100E2-39	SWITCH
17		AR (21)			17		M39029/31-240	PIN
17		AR (21)			17		M39029/32-259	SOCKET
		AR (2)					M39029/31-228	PIN
		AR (2)					M39029/32-247	SOCKET
1	1			1	1	1	MS20253-1-065	PIN
		3					MS21042L06	NUT
1	1			1	1	1	MS21042L08	NUT
1	1	1	1	1	1	1	MS21042L3	NUT
		2					MS21044N04	NUT
1	1	1	1	1			MS21919WDG10	CLAMP
		1	1	1			MS21919WDG19	CLAMP
1	1						MS21919WDG20	CLAMP
		1					MS24523-27	SWITCH
		2					MS24693-S7	SCREW
4	4	4	4	4	4	4	MS24693-24B	SCREW
1	1	1	1	1	1	1	MS27039-1-07	SCREW
		1					MS27212-1-3	TERMINAL BOARD
1					1		MS3126E14-19P	PLUG
1					1		MS3120E14-19S	SOCKET
		2					MS3126E16-99P	PLUG
		1					MS3120E16-99S	SOCKET
		3					MS3373-A1	STRIP
2	2	2	2	2			NAS1149D0363J	WASHER
					2	2	MS24665-289	COTTER PIN
1	1	1	1	1	1	1	D212-803	KIT PAPERWORK



DART Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 5200
Fax: 613 632 5246
accounting@dartaero.com

INVOICE * REPRINT *****

Invoice ID : INV128276
Sales Order ID : SO126107
Invoice Date : 4/29/2016
Ship Date : 4/29/2016 3:12:00 PM
Customer PO ID : M14017

Page Number : Page 1 of 1

Prepared By :

Bill To : CCONS01

CHI AVIATION
3679 BOWEN ROAD
HOWELL, MI 48855
USA

Ship To :

HELIMAX AVIATION
5825 PRICE AVE
MCCLELLAN,, CA 95652
USA

Order Date: 4/29/2016 9:44:14 AM

Freight Acct #: 2018 7619 2

AR Terms: Net 30

Due Date	Amount
5/29/2016	\$2,701.00

FOB: Ex Works DART Aerospace
Currency Type : USD
Ship Method: FedEx Overnight
AWB: 561296090142

Line Nbr/	Item ID / Item Name	Unit of Measure	Shipped Qty	CD	Unit Price	Discount %	Sales Tax	Extended Price
1	D5155-047/Go-Pilot Collective Head Assembly (205)	Each	1.0000	FN	\$2,701.0000	0.00%	0.00%	\$2,701.00
			Backorder Qty :	0.0000				

Lot Number

136795

Lot Trans Qty

1

Line Item Total: \$2,701.00

New Order
making
D205.803.223
Qty 1

Subtotal:	\$2,701.00
Sales Tax:	\$0.00
Shipping Charges:	\$0.00
Total:	\$2,701.00
Payments Received:	(\$2,701.00)
Balance Due:	\$0.00

Remittance Address:

Remittance address as stated above.
Note: A minimum 15% restocking fee is applicable on all standard items.
Custom items are non-refundable. Full warranty and return authorization
details are available at www.dartaerospace.com
GHST/HST 10127 2607